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SAKURAI MASATOSHI****(54) MANUFACTURE OF SYNTHETIC RESIN DOLL MEMBER****(57) Abstract:**

PURPOSE: To uniformly manufacture a synthetic resin doll member with high productivity by a method wherein resin is injection-molded to a core member consisting of composite of metal and synthetic resin.

CONSTITUTION: A cavity S for molding the leg member of a doll is formed respectively on a pair of injection-molded halves 20 and 21. At the same time, an insertion hole 22 is formed at the upper end of the cavity S on the mold half 20. In addition, a pinching part 23 is formed at the lower end of the cavity S in the mating mold surfaces of both the mold halves 20 and 21. Firstly, a core material 1 is set in the molding cavity S of the mold halves 20 and 21. Secondly, molten vinyl chloride resin with a temperature of 170V180°C is injected in the mold halves 20 and 21 by conventional procedure. In this case, because both the gaps are held through the contact of the tips of gap holding projections 16 with the inner wall 20a of the mold half, no shifting of the core member due to the fluid pressure of resin applied to an aggregate 3 occurs. Finally, after the completion of molding, a doll member is

removed from the mold halves 20 and 21 and a gate is cut off and mold flashes are removed.

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